

Work Order ID 158814-3

158814

Page 1

Friday, March 31, 2017 7:15:41 PM

Item ID: D5354-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/6/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan:

Date: MAR 31 2017 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5354	C

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks at 4.250"

0.00

0.02

17-04-03

3

0

DAS
08
0.00

110

110

HAAS SAXIS

HAAS CNC vertical machine #5

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB436 (D5354-1)

DWG REV: C

FOLIO REV: AA

1.26

3.80

17-04-08

3

0

DAS
08
0.00

2- deburr and break all sharp edge as per dwg

Work Order ID 158814

Friday, March 31, 2017 7:15:41 PM

158814

Page 2

Item ID: D5354-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017 Start Qty: 3.00 *3*

Required Date: 4/6/2017 Req'd Qty: 3.00 *3*

Reference: SCHEDULED

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.08				3	φ		DAS C8 9-89
120									
QC	Memo	0.50							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130									
QC	Memo	0.06							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							DAS 13 9-89
140						3		APR 19 2017	
Outsource4	Memo	216.00							
Outsource process - Anodize	Issue P/O to ATG : 36011								
	Black Anodize as per Dwg D5354								
	Certification of Comformity is required.								

Work Order ID 158814

Friday, March 31, 2017 7:15:41 PM

158814

Page 3

Item ID: D5354-041

Accept

N900040100Setup Start ***NS1*****Revision ID:**Stop ***NS2*****Item Name:** R66 Fwd Clamp Assembly, LH**Start Date:** 4/4/2017 **Start Qty:** 3.00 ***3*****Cust Item ID:****Required Date:** 4/6/2017 **Req'd Qty:** 3.00 ***3*****Customer:****Reference:** SCHEDULEDRun Start ***NR1*****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____Stop ***NR2*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.06							
Packaging	Certification of Conformity is required.								
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.06							
Quality Control									

3X 5017-511

3

MAY 11 2017

Work Order ID 158814

158814

Page 5

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N900040100

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Start Date: 4/4/2017 Start Qty: 3.00

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Cust Item ID:

Required Date: 4/6/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Identify as per dwg & Stock Location: 51576

0.00

180

Packaging

Memo

0.03

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.30

Quality Control

Accept Qty 1

Reject Qty DAS 6
9-89

JUL 06 2017

17/7/4 JA

DAS
21
9-89

JUL 06 2017

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 1

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM
REV:B 16.01.26 REV.A DWG DD VERF:JLM
16/07/08 Per rev.B dwg. JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.250X04.50
0

Purchased

No

100

f

8.0764

0.354

1.117895

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

G.A. 17-04-05

Location

Loc Qty

Loc Code

MAT004

8.0764

m133038

0.3014

→ m134776

7.775

160

Each

9.0000

1

3

JUL 06 2017

DAS
19
9-89

D5316-1

Manufactured

No

D5316-1

T-Bolt Strap

not pulled

Location

Loc Qty

Loc Code

ST163

9

155235

9

160

Each

0.0000

2

6

JUN 19 2017

D5351-1

Manufactured

No

D5351-1

T-Bolt Spacer

158932

2

DAS
30
9-89

B 160624

4

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 2

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

160

Each

936.0000

2

6

DAS
30
9-89

MS21043-3

Nut

JUN 19 2017

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

203

m130673

11

m136182

192

GA

215

m133990

27

m136182

188

ST302

369

m136986

369

ST304

69

m131340

69

M137459

(4)

NAS1149D0332J

Purchased

No

160

Each

1,682.000

2

6

DAS
30
9-89

NAS1149D0332.J

Washer

JUN 19 2017

Location

Loc Qty

Loc Code

FP

28

m136015

28

GA

522

m136643

522

ST260a

1000

m137075

1000

ST264

132

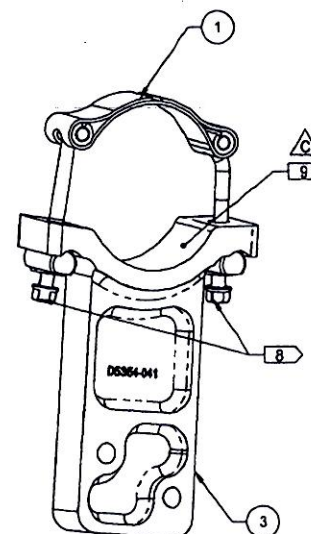
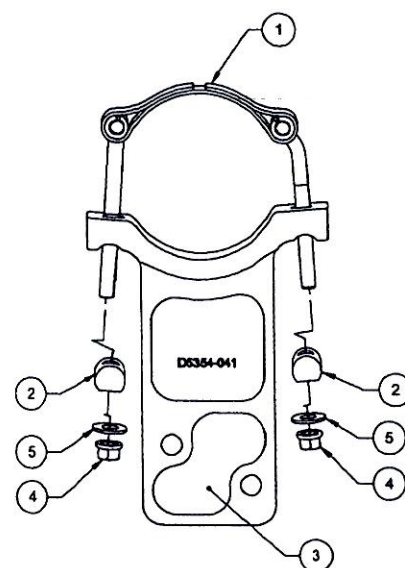
m136015

132

BH 137732

(4)

ITEM	QTY	P/N	DESCRIPTION
	X	D5354-041	R66 FWD CLAMP ASSY, LH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-1	SUPPORT, LH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-041 R66 FWD CLAMP ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: AS SHOWN ON D5354-1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

C	ADDED ENGRAVING AND REVISE NOTE 8 AND LOCATION OF PROSEAL (ZN AB-1, C3-1, AB-2 C3-2, AB-3, C2-3, C7-3, AB-4, B2-4, C8-4)	RF	17.02.09
B	REDESIGN -1/041, ADD -2/042, REMOVE -043 (ZN AS-1, AS-2, AS-3, AS-4); ADD NOTE 9 (ZN AB-1, AB-2)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	17.02.09		

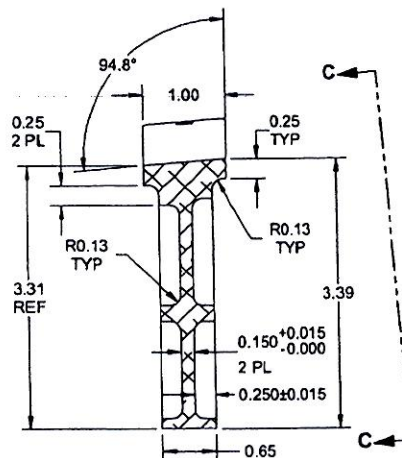
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5354** REV. C
SHEET 1 OF 4
TITLE **R66 FWD CLAMP ASSEMBLY** SCALE NTS

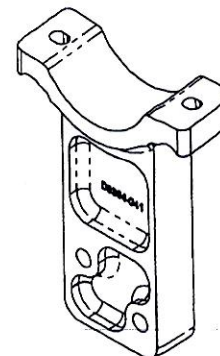
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RELEASED
2017-03-22
17-535

APPROVED



SECTION A-A



D5354-1 SUPPORT, LH

NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH ASSEMBLY P/N, FWD & ARROW PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
 - 7) WEIGHT: 0.29 lbs
 - 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-1 REV. C.SLDPRT

RELEASE
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5354	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND ISSUED FOR THE EXCLUSIVE USE OF THE CUSTOMER FOR WHOM IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT	

DART AEROSPACE LTD	Work Order: 158814
Description: SUPPORT LH	Part Number: D5354-1
Inspection Dwg: D5354 Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.274	+/- .010	0.276	✓		Vern	GA-13
0.20	+/- .030	0.199	✓		"	"
Φ0.204	+ .005 / - .001	Φ0.204	✓		"	"
0.50	+/- .030	0.497	✓		"	"
R0.27	+/- .030	R0.266	✓		R-6	ref.
Φ0.257	+ .006 / - .001	Φ0.260	✓		Vern	GA-13
1.28	+/- .030	1.275	✓		"	"
0.13	+/- .030	0.124	✓		Mic	GA-03
R0.25	+/- .030	R0.250	✓		R-6	ref.
1.000	+/- .005	1.000	✓		H-6	31006
1.67	+/- .030	1.669	✓		Vern	GA-13
0.31	+/- .030	0.310	✓		"	"
0.50	+/- .030	0.499	✓		"	"
0.500	+/- .005	0.499	✓		H-6	31006
0.15	+/- .030	0.150	✓		Vern	GA-13
0.13	+/- .030	0.125	✓		Mic	GA-03
R0.30	+/- .030	R0.297	✓		R-6	ref.
R0.13	+/- .030	R0.125	✓		"	"
0.25	+/- .030	0.238	✓		H-6	31006
94.8°	+/- 1/2°	94.8°	✓		Angle M.	CNC-17
1.00	+/- .030	0.998	✓		Vern	GA-13
0.25	+/- .030	0.254	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
3.39	+/- .030	3.394	✓		H-6	31006
0.150	+ .005 / - .000	0.155	✓		Mic	118-120
0.250	+/- .015	0.2475	✓		D-6	GA-08
0.14	+/- .030	0.140	✓		Vern	GA-13
0.40	+/- .030	0.396	✓		"	"
3.04	+/- .030	3.041	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.
R0.20	+/- .030	R0.206	✓		"	"
R0.13	+/- .030	R0.125	✓		"	"

Measured by: D.A. DAS	Checked by: 14 DAS	QC Inspector:
Date: 17-04-08 08	Date: 17/04/11 PRO	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 013270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
ea	Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20958	PO: PO36011	Line: 4
25 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20959	PO: PO36011	Rev: A Line: 5
25 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20960	PO: PO36011	Rev: A Line: 6
20 ea	Part: D2348 Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20961	PO: PO36011	Rev: C Line: 7
20 ea	Part: D5351-1 T-Bolt Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20962	PO: PO36011	Rev: A Line: 8
3 ea	Part: D5354-041 R66 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20963	PO: PO36011	Rev: C Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Made in Canada.			

8917511



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

OUR TRUCK

Quantity

Description

Date:

05/05/2017

Certified Signature:

[Signature]

Receiver Signature:

[Signature]

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

Made in Canada.